



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7703

Job Sheet 201000



Part No: 647.7703

Job Qty: 20 pcs

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/20/19

Job Tracking No:

Due Date: 10/28/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV A2 IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Large Fab - Welded Assy-1	20 pcs	10/28/19		0.00	7.91	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		MV Nov 10/19
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
130	QC 9	20 pcs	10/28/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		a
							QC 9 - 9		
140	QC 5	20 ---	10/28/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		



Dart Aerospace
1270 Aberdeen St
Hawkesbury, ON K6A
CANADA
TEL: 1 613 632-5200
Email: sales@dartae
www.dartaerospace.

Container No: S229733



r647.7703

b No: 201000

erial No/Batch: S229733

ision:

ector:

Plex 9/20/19 10:15 AM Dart.Renwick.Jennifer

				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	EL
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150	Outsource - 3 - Cadplate	20 pcs	10/28/19	GRO002-VC	10
160	Packaging 2-1 - Receive - B4B	20 pcs	10/28/19	0.00 0.00	2019-11-12
				Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP NOV 21 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
170	QC 6	20 pcs	10/28/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
180	Spray Paint - 2 - B4B	20 pcs	10/28/19	0.00 1.14	Spray Paint - 1 - B4B
					Spray Paint - 2 - B4B

Plex 9/20/19 10:15 AM Dart.Renwick.Jennifer

				Spray Paint - 3 - B4B		
				Spray Paint - 4 - B4B		
190	QC 14	20 pcs	10/28/19	0.00 0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	NOV 2 5 2019
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
					200	Packaging 3-1 - Stock - B4B
Packaging 3 - 2 - B4B						
Packaging 3 - 3 - B4B						
Packaging 3 - 4 - B4B						
Packaging 3 - 5 - B4B						
Packaging 3 - 6 - B4B						
Packaging 3 - 7 - B4B						
Packaging 3 - 8 - B4B						
Packaging 3 - 9 - B4B						
Packaging 3 - 10 - B4B						
Packaging 3 - 11 - B4B						
Packaging 3 - 12 - B4B						
Packaging 3 - 13 - B4B						
Packaging 3 - 14 - B4B						
Packaging 3 - 15 - B4B						
Packaging 3 - 16 - B4B						
Packaging 3 - 17 - B4B						
Packaging 3 - 18 - B4B						
Packaging 3 - 19 - B4B						
Packaging 3 - 20 - B4B						
Packaging 3 - 21 - B4B						
Packaging 3 - 22 - B4B						
Packaging 3 - 23 - B4B						
Packaging 3 - 24 - B4B						
Packaging 3 - 25 - B4B						
Packaging 3 - 26 - B4B						
Packaging 3 - 27 - B4B						
Packaging 3 - 28 - B4B						
Packaging 3 - 29 - B4B						
Packaging 3 - 30 - B4B						
Packaging 3 - 31 - B4B						
Packaging 3 - 32 - B4B						
Packaging 3 - 33 - B4B						
Packaging 3 - 34 - B4B						
Packaging 3 - 35 - B4B						
Packaging 3 - 36 - B4B						
210	QC 21 - SA	20 pcs	10/28/19	0.00 0.00	QC 21 - SA - 21	

DA 2 9-89

NOV 2 5 2019

NOV 2 5 2019

Plex 9/20/19 10:15 AM Dart.Renwick.Jennifer

DAS
40
9-89DA
2
9-89

NOV 2 5 2019

NOV 2 5 2019

Plex 9/20/19 10:15 AM Dart.Renwick.Jennifer

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 120 - Weld per dwg A/R 4130 rod Batch: M127435 - 1- ASSEMBLE AND WELD AS PER DWG ***IMPORTANT
 Descriptions: DIMENSION IS 8.35" ***

130 - QC9- Inspect visual per QSI004- Fusion Welds

140 - QC5- Inspect part completeness to step on W/O

150 - Issue P/O : 45076 Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II *****NOTE: limite cad
 platting on thread to 0.003" or less****

160 - Receive & Inspect for Damage & Mat'l Certs

170 - INSPECT USING GO/NO GO GAUGE

180 - Spray Paint / NDT Room - PRIOR TO PRIME MASK THREAD AND PRIME AS PER DWG 5195271

190 - QC14- Inspect Spray Paint

200 - Identify as per dwg & Stock Location: _____

210 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.7712	Strut Tube	20 pcs (1 ea)	120-Large Fab - Welded Assy-1	<u>5222553</u>
647.7713	Strut Thread	20 pcs (1 ea)	120-Large Fab - Welded Assy-1	<u>5222914</u>
647.7714	Strut Tube	20 pcs (1 ea)	120-Large Fab - Welded Assy-1	<u>5219908</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Large Fab - Welded Assy-1	647.7712	20	17	0
	647.7713	20	12	0
	647.7714	20	7	0

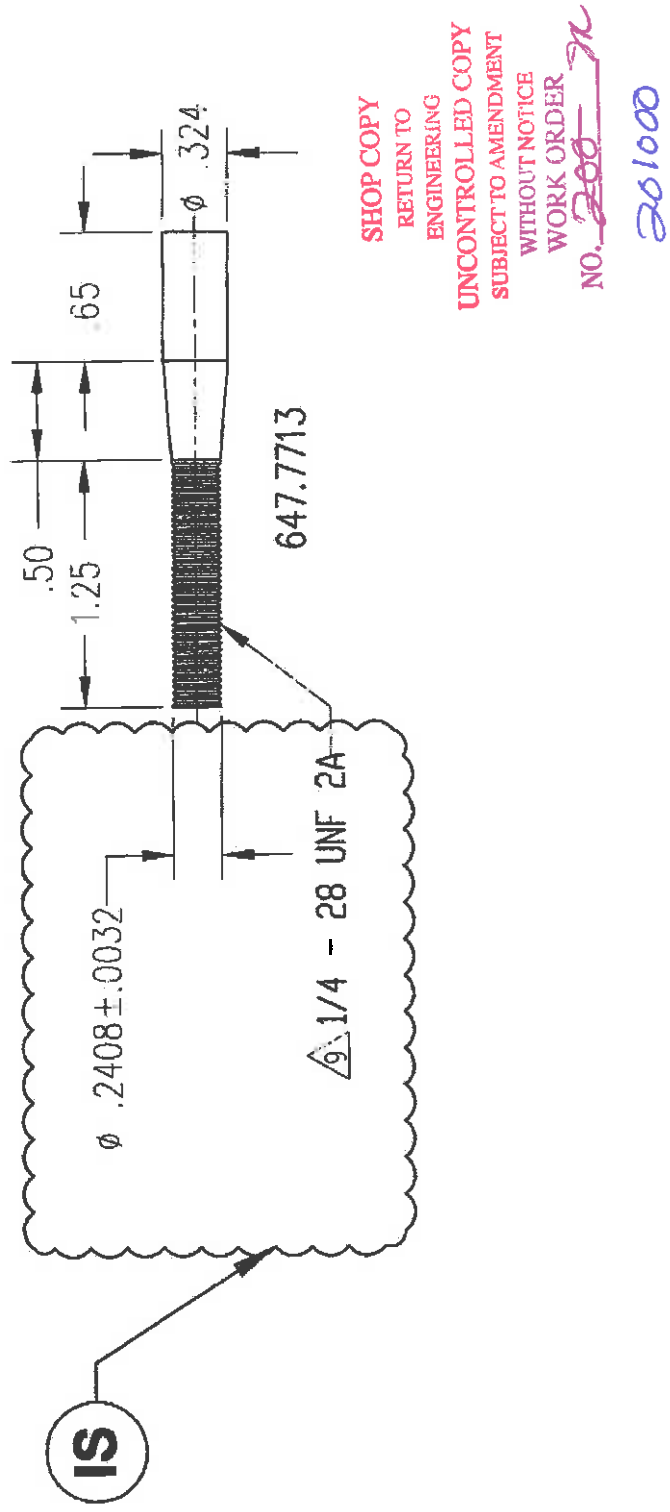
Part Specifications

Specifications could not be found.

Plex 9/20/19 10:15 AM Dart.Renwick.Jennifer

ENGINEERING CHANGE NOTICE NO. 05397		SHEET 1 OF 1	
DWG NO. 647.7700	REV: A	DATE: 05/02/16	EFFECT ON DWG ☐ INC. ☒ UNINC.
DWG TITLE: STRUT ASSY			
APPROVED BY:	ENGR	MFG	QC
REASON: REVISED DIMENSION			
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		ECR: 16-028	CURRENT ORDER
		ACTION LIST: 1.	

SHEET 2, ZONE D4 IS:



DOCUMENTS EFFECTED:	☐ PATTERN	☐ MDL	☐ INSTALL INSTRU	☐ ICA	☐ BOM	CHANGE CATEGORY	☐ MAJOR	☒ MINOR	DER REVIEW REQUIRED	☐ YES	☒ NO
----------------------------	----------------------------------	------------------------------	---	------------------------------	------------------------------	------------------------	--------------------------------	---	----------------------------	------------------------------	--

10

NOTES:

05/10, 05397.



ST 2 11 00

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS	
		Rework ☐ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042) _____	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	
		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
		Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB045076



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3866
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045076

PO Date: 11/12/19

Due Date: 11/20/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-11-14

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	201890	647.7702	647.7700 Rev A2	Strut Assembly : Various STC's Outsource3 (Outsource process-Cadplate per QSI017 4.1.9.1) Issue P/O _____ Group Altech CAD PLATE IAW QQ-P- 416F CLASS I TYPE II note: cad plate should not be too thick around tread	Firmed	-	11/20/19	8 pcs	0 pcs	8 pcs	\$15.89/pcs	\$127.12
2	201000	647.7703	647.7700 Rev A2	Strut Assembly : Various STC's Issue P/O _____ Group Altech CAD PLATE IAW QQ-P- 416F CLASS I TYPE II ****NOTE: limit cad plating on thread to 0.003" or less****	Firmed	-	11/20/19	10 pcs	0 pcs	10 pcs	\$12.35/pcs	\$123.50
	200600				Firmed	-	11/20/19	10 pcs	0 pcs	10 pcs	\$12.35/pcs	\$123.50
Sub Total:								20	0	20		\$247.00
Grand Total:												\$374.12

Guerin



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045076



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/14/19 12:49 PM Dart.Guerin.Kimberley

**Certificat de Conformité / Certificate of Compliance**
(024054-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip**024054 - 1**

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
20-Nov-2019		Jigar Patel				POHB045076				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qté		Qté Scrap/	À venir / Back Order
1	647-7702 Rev.A2	647-7700 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER IAW QQ-P-416F CLASS - 1, TYPE - 2 0.0005" (CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD)		CADMIUM CH	8	8	0	0	0	
2	647-7703 Rev.A2	647-7700 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER IAW QQ-P-416F CLASS - 1, TYPE - 2 0.0005 " (LIMIT CAD PLATING ON THREAD TO 0.0003 " OR LESS)		CADMIUM CH	10	10	0	0	0	DA 40 9-88
3	647-7703 Rev.A2	647-7700 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER IAW QQ-P-416F CLASS - 1, TYPE - 2 0.0005 " (LIMIT CAD PLATING ON THREAD TO 0.0003 " OR LESS)		CADMIUM CH	10	10	0	0	0	

RECEIVED
NOV 21 2019
DART AEROSPACE LTD.

DAS
40
8-89

RECEIVED
NOV 23 2019
DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual ThicknessInspecteur Qualité
Quality InspectorRéçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.